

Date: Thursday, 12/13/2007 2:38:53 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 36322		Part Number	: D2571		
Estimate Number	: 10530		Drawing Number	: D2571 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	: 12/13/2007	S.O. No. :	Drawing Revision	: E		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type :	Due Date	Qty:	16	Um: Each
Previous Run	: 35931					
Written By	:					
Checked & Approved By	:					
Comment	: Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <u>034875</u> SF 08/01/14			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>36322</u> Double check by: <u>36</u> PBO 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. DSP / 36 / SF 08/01/14			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572 36 / DSP 08/01/20			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 36 / DSP 08/01/20			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: 1/A Fault Category: Pro - manu NCR: Yes No DQA: 1 Date: 08/01/25
 QA: N/C Closed: 1 Date: 08/01/28

NCR: <u>36322</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/14	2.0	Z origin was off by .125". human error first time Dary saddle set ups.	<u>MD</u> <u>08/01/14</u>	Scrap and Destroy and Replace Part <u>XL</u> <u>B# 3-1875</u>	<u>8/1</u> <u>08/01/14</u>	<u>08/01/14</u>	<u>LLB</u> <u>08/01/14</u>	<u>LLB</u> <u>08/01/14</u>

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 2:38:53 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 36322

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 08/01/22

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

11

08-01-22

16

7.0 POWDER COATING POWDER COATING



M 106379



16X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ML

08/01/22

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



AS HL



16X

Comment: INSPECT POWDER COAT

08-01-23

9.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST432

KS 08/01/24

X16

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08 01 25

Comment: FINAL INSPECTION/W/O RELEASE

2008/1/24

W

Job Completion



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	36322
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.441	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.997	8.000	8.000	8.000		
F	0.490	0.510		.497	.500	.505	.505		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.501	.505	.505	.505		
J	1.174	1.184		1.180	1.179	1.179	1.179		
K	0.558	0.578		.569	.562	.562	.562		
L	1.174	1.184		1.180	1.179	1.179	1.179		
M	1.490	1.500		1.500	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.876	3.874	3.874	3.874		
P	0.115	0.135		.124	.127	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.244	.248	.248	.248		
S	0.115	0.135		.135	.130	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.960	2.960	2.960		
V	0.230	0.250		.240	.242	.242	.242		
W	0.115	0.135		.135	.122	.122	.122		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.367	.367	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.635	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.384	1.385	1.385	1.385		
AF	0.115	0.135		.128	.128	.128	.128		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.252	.252	.252		
AI	2.000	2.020		2.006	2.001	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: 815 136
Date: 08/01/14

Audited by: 50
Date: 08/01/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	2011

DART AEROSPACE LTD				Work Order:	36322
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

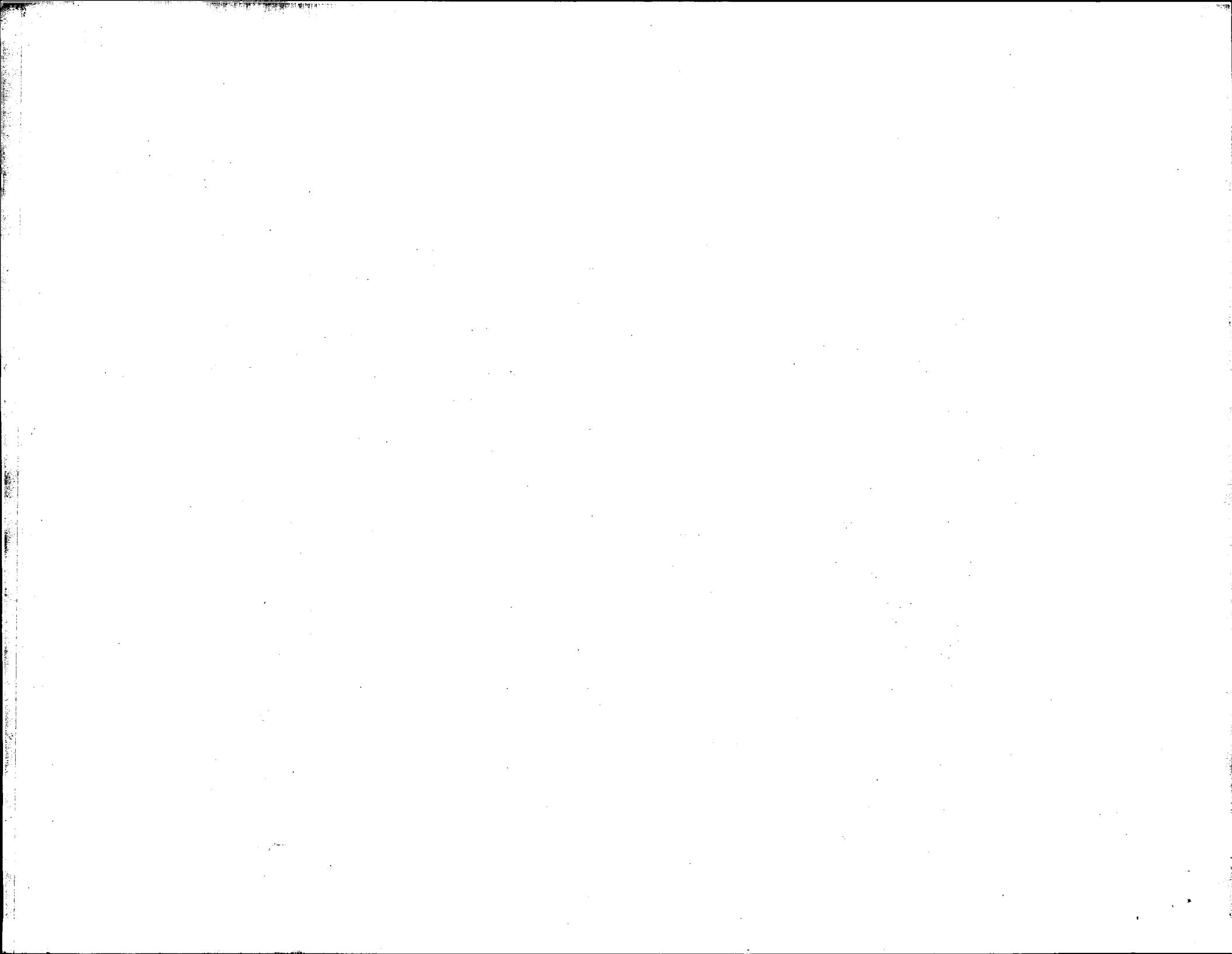
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5/8	6/8	7/8	9/16	By	Date
A	0.438	0.443	DT8682	.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.007	8.002		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.500	.500	.503	.503		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.500	1.500	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.125	.125	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.125	.125	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.125	.125	.126	.126		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.360	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.260	.260		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: ST
Date: 08/01/17

Audited by: 08/01/22
Date: SD

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>ST</u> <u>SD</u>



DART AEROSPACE LTD				Work Order:	36322
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				91	102	113	124		
A	0.438	0.443	DT8682	.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.75	1.75		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.502	.502	.502	.502		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.377	.377		
I	0.490	0.510		.505	.505	.503	.503		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.126	.126		
Q	0.115	0.135		.135	.135	.135	.130		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.127	.127	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.962	2.963	2.963		
V	0.230	0.250		.238	.240	.243	.240		
W	0.115	0.135		.127	.127	.127	.127		
X	0.308	0.313		.310	.310	0.311	.311		
Y	0.760	0.765		.760	.760	0.760	0.760		
Z	0.352	0.372		.368	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.620	.618	.618		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.388	1.381	1.381	1.381		
AF	0.115	0.135		.125	.125	.128	.128		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.254	.254		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	S.F / DSP	Audited by:	SD
Date:	08/01/19	Date:	08/01/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SJM

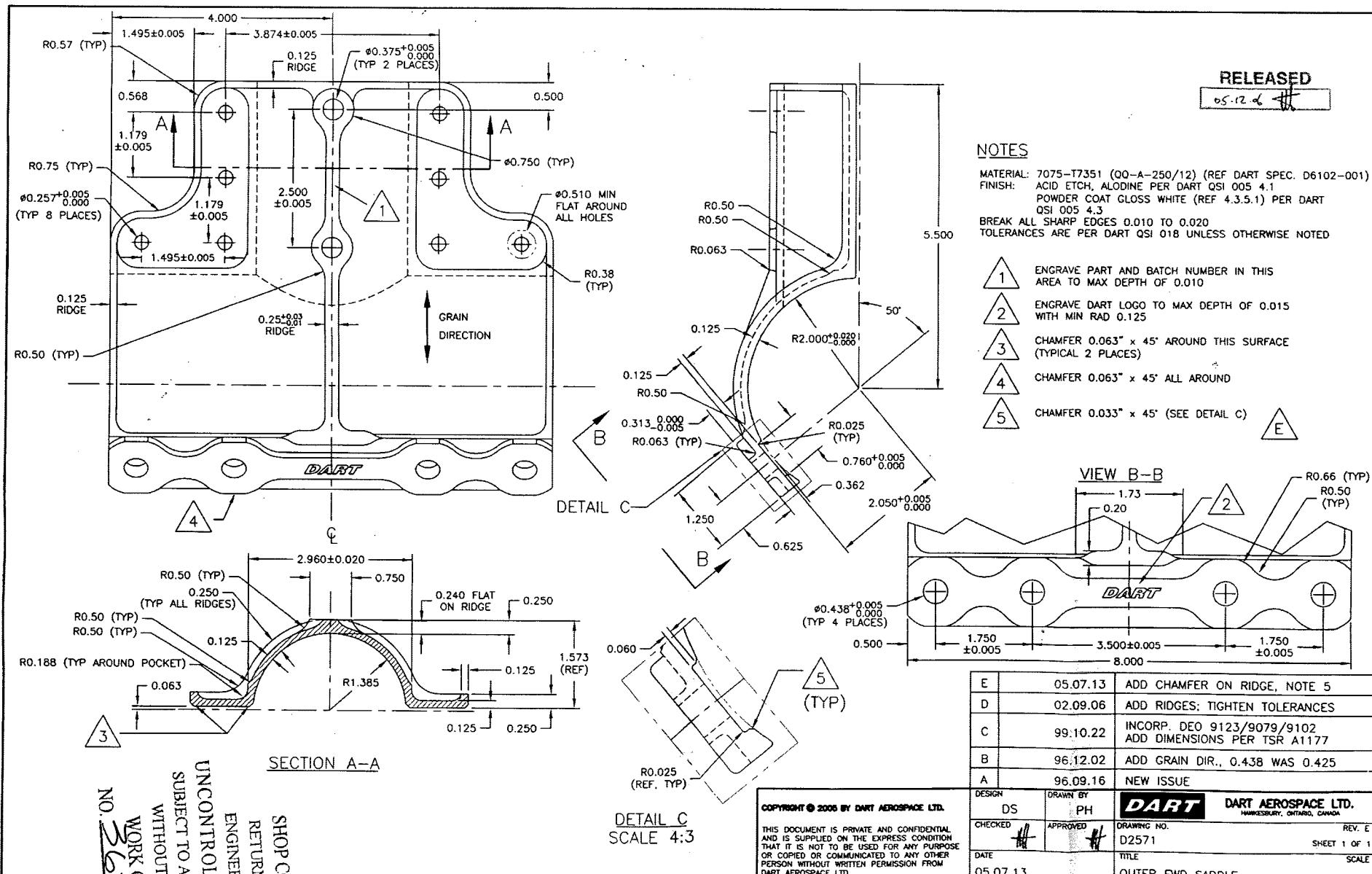
DART AEROSPACE LTD				Work Order:	36322
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					
				13	14	15	16	By	Date
A	0.438	0.443	DT8682	.441	0.441	0.441	.441		
B	1.745	1.755		1.748	1.748	1.748	1.749		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.748	1.748	1.749		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.501	.501	0.501	0.499		
G	0.257	0.262	DT8683	.258	.260	0.260	.260		
H	0.375	0.380	DT8684	.376	0.377	0.377	.377		
I	0.490	0.510		.500	0.503	0.503	0.501		
J	1.174	1.184		1.180	1.180	1.1785	1.179		
K	0.558	0.578		0.568	0.568	0.568	0.568		
L	1.174	1.184		1.180	1.179	1.1785	1.179		
M	1.490	1.500		1.500	1.495	1.494	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	0.126	0.128		
Q	0.115	0.135		.135	0.135	0.135	.135		
R	0.240	0.260		.250	0.247	0.247	0.247		
S	0.115	0.135		.130	0.130	0.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	0.240	0.240		
W	0.115	0.135		.126	.126	0.126	0.126		
X	0.308	0.313		0.310	0.310	.310	0.310		
Y	0.760	0.765		.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.364	0.364	0.364		
AA	0.470	0.530		.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	.628	0.628	0.628		
AC	0.053	0.073		.063	.063	0.063	.063		
AD	0.240	0.260		0.250	.250	0.250	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	.135		
AG	0.240	0.280		.260	0.260	.260	.260		
AH	0.240	0.260		0.250	0.250	.250	.250		
AI	2.000	2.020		2.00	2.00	2.000	2.000		
AJ	0.023	0.043		0.033	.033	0.033	.033		
Accept/Reject									

Measured by:	8-F / DSP	Audited by:	SA
Date:	05/01/14	Date:	03/01/22

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SA



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 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 36322